

Work Order ID 57259

March 31, 2010 10:34:52 AM



Page 1

Item ID: D3564-11

Revision ID:

Item Name: Wearshoe

Start Date: 31/03/2010 Start Qty: 12.00

Required Date: 31/03/2010 Req'd Qty: 12.00

Reference:

Approvals:	Process Plan:	Accept	Setup	Start	Barcode
	QC:	Date: 103-31	Tooling:	Date:	Barcode
		Date:	SPC (Y/N):	Date:	Barcode

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3564	Rev D								

100 Waterjet FLOW WATER JET 0.00

Waterjet
FLOW CNC Waterjet
304 .063

Memo 0.00
1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

B10-4-6

110 QC QC2- Inspect parts off machine FAI/FAIB 0.00

QC
Quality Control

Memo 0.00

HB10-4-4

120 QC QC8- Inspect parts - second check 0.00

QC
Quality Control

Memo 0.00

Swallow

114

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57259

March 31, 2010 10:34:52 AM



Page 2

Item ID: D3564-11

Accept



Setup

Start



Stop



Revision ID:

Item Name: Wearshoe

Start Date: 31/03/2010 Start Qty: 12.00



Required Date: 31/03/2010 Req'd Qty: 12.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

SD 10/4/07 14 08

S 10/4/08

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(14)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat Weld hardcoat as per Dwg D3437

M 113521

EL 10-4-12 (14)

W/O:		WORK ORDER CHANGES					
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Work Order ID 57259

March 31, 2010 10:34:52 AM



Page 3

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 31/03/2010 Start Qty: 12.00



Required Date: 31/03/2010 Req'd Qty: 12.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 10/04/12

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/12

0.00

(X14)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

=) M 10/04/13

START TIME: 7:15AM FINISH TIME: 7:45AM OVEN TEMPERATURE: 320F

(X14)

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 57259

March 31, 2010 10:34:52 AM



Page 4

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Start Date: 31/03/2010 Start Qty: 12.00



Required Date: 31/03/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling: Date:

Run Start



QC:

Date: SPC (Y/N): Date:

Stop



Sequence ID/

Work Center ID

190



QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

BL 10-4-13

(94)

200



Packaging

Packaging

Identify as per dwg & Stock Location: EP-19

0.00

10/04/13

(X14)

Q

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/13 JJ

BL 10-4-13
(14)

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NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:34:56 AM

Page 1

Work Order ID: 57259



Parent Item: D3564-11



Parent Item Name: Wearhoe

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Start Date: 31/03/2010

Start Qty: 12.00

Required Date: 31/03/2010

Required Qty: 12.00

M304S16GA



304/316 Sheet .063

Purchased	No	100	sf	138.6899	17.8105
-----------	----	-----	----	----------	---------

21.

1810-4-6

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT20	138.6898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	75.6049	

113295

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DART AEROSPACE LTD	Work Order:	57259
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-4-6	Date:	10/04/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	JK

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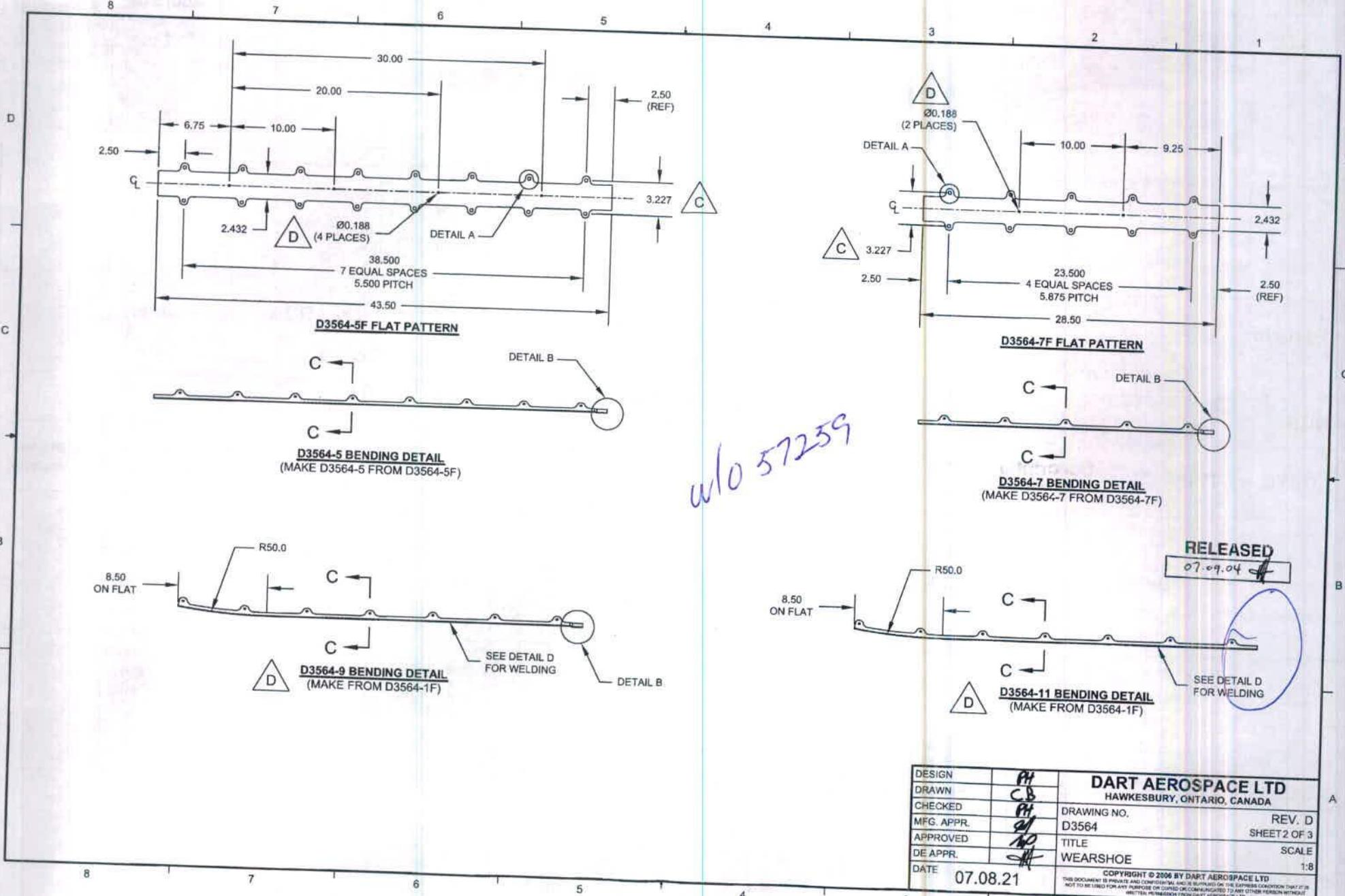
NOTE: Date & initial all entries

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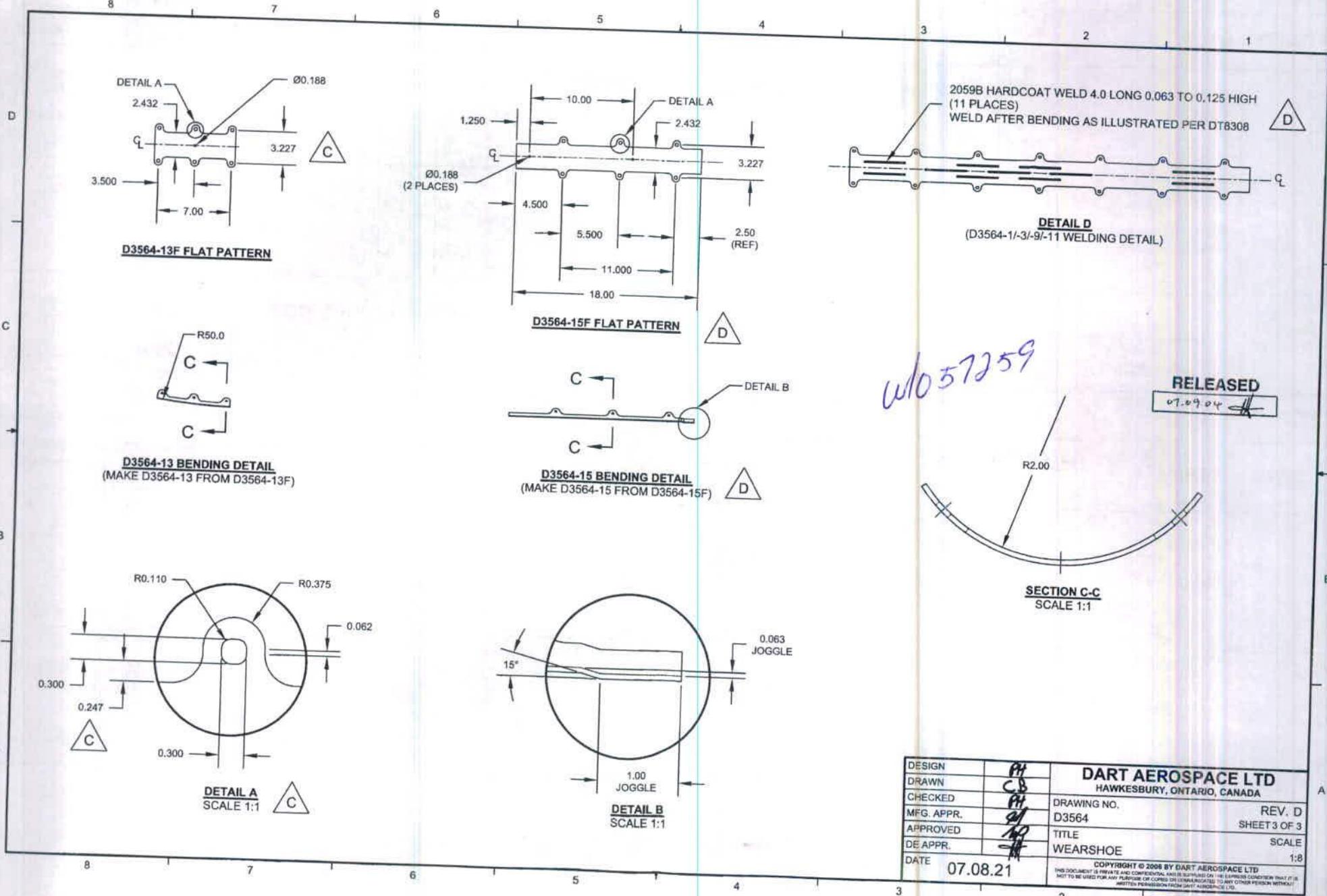


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NOTE: Date & initial all entries



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	REV. D	
MFG. APPR.	SI	DRAWING NO.	SHEET 3 OF 3
APPROVED	10	D3564	
DE APPR.		TITLE	SCALE
DATE	07.08.21	WEARSHOE	1:8

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